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RB T103347-101
Job Sheet 194932



Part No: RB T103347-101

Job Qty: 3 pcs

Part Name: Cyclic Stick Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/10/19

Job Tracking No:

Due Date: 7/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *oreln 16251*

Note: DWG RB T103347-101 Rev 2 IPP Rev. A 19.05.06 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	7/8/19		0.25	1.50	Small Fab - 1		<i>MCL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	7/8/19		0.00	0.00	QC 5 - 10		<i>UM</i> <i>July 81</i> <i>2019</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	3 pcs	7/8/19		0.00	0.00	QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S201947



Part: RB T103347-101

Job No: 194932

Serial No/Batch: S201947

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 07/31/19

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	DAS
				Packaging 3 - 24 - B4B	18
				Packaging 3 - 25 - B4B	2-00
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	3 pcs	7/8/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 100 - (Small Fab) Assemble as per drawing.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
38 23-006C00-22-16	Bushing	3 Ea (1 ea)	100-Small Fab - 1	5181196
38 23-006C16-22-16	Bushing	6 Ea (2 ea)	100-Small Fab - 1	5181702
701 AN122721	Pin	3 Ea (1 ea)	100-Small Fab - 1	5183561
201 AN44-6	Bolt	3 Ea (1 ea)	100-Small Fab - 1	5183241
AN860PD416	Washer SEE PART NAS1149D0463K 019	9 Ea (3 ea)	100-Small Fab - 1	5183307
34 MS16555-641	Pin 5183299	6 Ea (2 ea)	100-Small Fab - 1	7K 5182446 2K 5183245
34 MS20074-04-06	Bolt	9 Ea (3 ea)	100-Small Fab - 1	5183299
11 MS21042L5	Nut	3 Ea (1 ea)	100-Small Fab - 1	FM 127813-90
34 MS35426-29	Wing Nut	3 Ea (1 ea)	100-Small Fab - 1	5184790
st 263 NAS1149D0563J	Washer	3 Ea (1 ea)	100-Small Fab - 1	5174288
26 NAS6605-22	Bolt	3 Ea (1 ea)	100-Small Fab - 1	5183283
RB T1103347-103	TBD	3 (1 ea)	100-Small Fab - 1	5000017
152F RB T1103347-115	TBD	3 (1 ea)	100-Small Fab - 1	5192762
150B RB T1103347-117	TBD	3 (1 ea)	100-Small Fab - 1	5186330

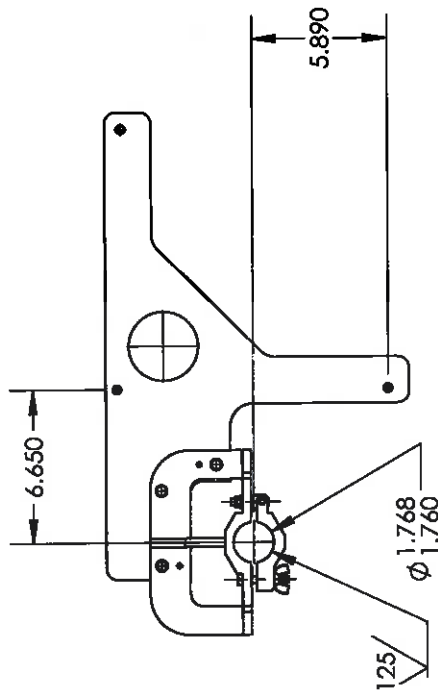
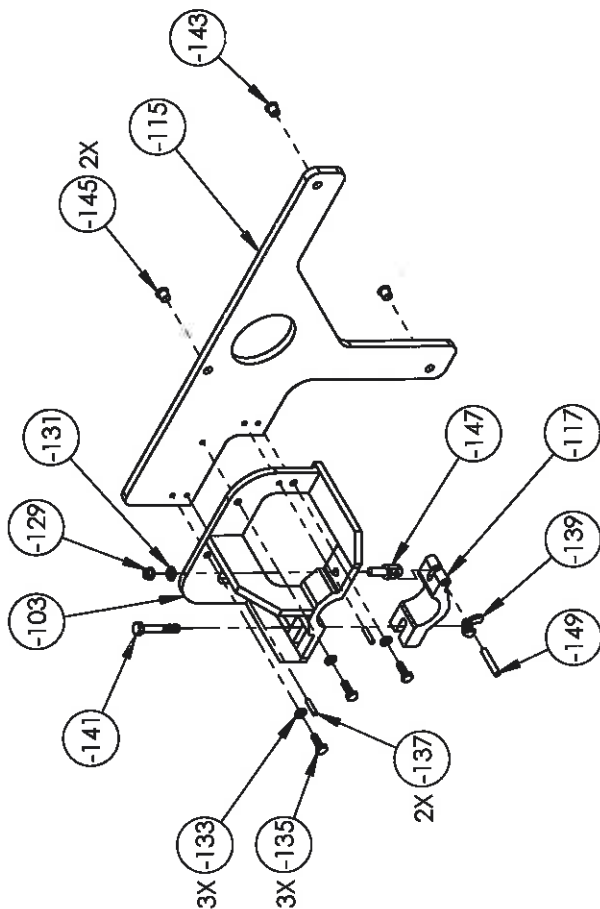
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	23-006C00-22-16	3	0	0
	23-006C16-22-16	6	0	0
	AN122721	3	0	0
	AN44-8	3	0	0
	AN960PD416	9	0	0
	MS16555-641	6	0	0
	MS20074-04-06	9	0	0
	MS21042L5	3	741	0
	MS35426-29	3	0	0
	NAS1149D0563J	3	3,275	0
	NAS6605-22	3	0	0
	RB T103347-103	3	0	0
	RB T103347-115	3	0	0
	RB T103347-117	3	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/10/19 10:37 AM Dart.lajeunesse.marie

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDRAWN IN SOLIDWORKS FROM TATTERED DRAWING -115 CHD LIMIT DIM WAS Ø.1875-1870 IS .1875-1880-117 CHD DIM WAS 4X R.04 IS 4X R.13. -127 CHD DIM WAS 2X R.06 IS 2X R.13.	6/16/2014	DPD	RJC
2	15-0197	-103 ADDED DIM (5.25). -115 ADDED ENGRAVE T/N. S/N. MADE IN USA NOTE.	8/5/2015	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194932 M5

NOTE:
REF. BELL T/N: T103347 REV A. 19-05-13



TITLE
CENTERING, PILOTS CYCLIC STICK

DWG NO. RB T103347-101

REV 2

DRAWN BY: DUERFELDT

APPROVED

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ± 1/32
DECIMALS ± .005
ANGLES ± .5°
FINISH
EPEC

1. BREAK ALL SHARP EDGES .015 x 45°
OR .018 R

2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

USED ON MODEL
BELL 412

SCALE 1:8 DATE 6/12/2014 SHEET 1 OF 9

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X		-103	1	SUPPORT ASSEMBLY			2
		-115	1	BASE	6061		3
		-117	1	CLAMP	6061		4
1		-119		BASE	6061		5
1		-121		ARM	6061		6
1		-123		ARM	6061		7
1		-125		ARM	6061		8
1		-127		HEAD	6061		9
	B/O	-129	1	NUT	STEEL	5/16-24 SPENCER #MS21042L5	1
	B/O	-131	1	WASHER	STEEL	Ø5/16 AIRCRAFT HARDWARE #AN960PD516	1
	B/O	-133	3	WASHER	STEEL	Ø1/4 AIRCRAFT HARDWARE #AN960PD416	1
	B/O	-135	3	BOLT	STEEL	1/4-20 AIRCRAFT HARDWARE #MS20074-04-06	1
	B/O	-137	2	DOWEL PIN	STEEL	Ø3/16 X 7/8 AIRCRAFT HARDWARE #MS16555-641	1
	B/O	-139	1	WING NUT	STEEL	5/16-24 AIRCRAFT HARDWARE #MS35426-29	1
	B/O	-141	1	BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #NAS6605-22	1
	B/O	-143	1	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C00-22-16	1
	B/O	-145	2	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C16-22-16	1
	B/O	-147	1	EYE BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #AN44-6	1
	B/O	-149	1	DOWEL PIN	STEEL	Ø1/4 X 1-1/2 AIRCRAFT HARDWARE #AN122721	1
ASSY -103							

Route update only

DEPARTMENT/PROCESS

Engineering			
Water Jet			
Supplier			
Quality			

QTY Affected :

MARB (QSI042)

Disposition

Lead hand / Supervisor

QC / QA Coordinator

	Operator
	Manufacturing Process
	Equip/Tooling
	Handling/Preservation
	Material
	Product Improvement
	Process Improvement
	Human Factors

	Pressure/Forced		Contamination			Power Loss/Surge			Positioned Wrong
	Bending		Misaligned/off center			Folio/Program			Outside Tolerance
	Crushing		BOM/Route			Grain Direction			Drawing
	Cracks		Broken/Damage/Defect			Weld			Finish
	Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions			Wrong Stock Pulled			Part Lost/Missing
	Marks/Chatter		Drill Holes			Out of Sequence			Misread
	Mislabeled		Fit/Function			Off-set/Set-up			

Other/Details: